



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

ASAP

D3219-1
Job Sheet 176851



Part No: D3219-1

Job Qty: 120 ea

Part Name: Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/2/18

Job Tracking No:

Created By: Linda Lacelle

Due Date: 5/11/18

Type: SOLD

Description:

Note: DWG REV B IPP A 04.04.19 New issue KJ/JLM ESR B 06.05.25 Waterjet EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	120 Ea		5/11/18	0.00	0.00	Start Up Waterjet		SC 8/5/03
100	Waterjet	120 pcs		5/11/18	0.01	2.50	Waterjet1		SL 8/5/03
120	QC	120 pcs		5/11/18	0.00	0.00	QC8		38
150	Packaging	120 pcs		5/11/18	0.00	0.00	Packaging3		D.M.L. 9-88
160	QC21-SA	120 Ea		5/11/18	0.00	0.00	QC21		18-5-3

Part Op 100 - 1-Cut as per Dwg D3219
Descriptions: 150 - *** STOCK IN STEP CELL***

DAS
21
9-80
MAY 04 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	11.5680 sf (.0964 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.125	12	126	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plate	0.316inches + 0.006 - 0.001	0.322 0.315	0,316	
2	Plate	2.293inches ± 0.005	2.298 2.288	2,294	
3	Plate	0.375inches ± 0.010	0.385 0.365	0,378	
4	Plate	0.125inches ± 0.010	0.135 0.115	0,128	
5	Plate	0.125inches ± 0.010	0.135 0.115	0,123	

Plex 5/2/18 10:12 AM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Dev

Part: D3219-1
 Job No: 176851
 Serial No/Batch: S068282
 Revision:
 Inspector:



DART
 AEROSPACE
 Container No: S068282

Completed By

 ad hand / Supervisor
 approval Verification

 C / QA Coordinator
 Approval

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 www.dartaerospace.com

Date: 05/03/18

Root Cause

Environment ☐	No Re-verification ☐	Press ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bendi ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centr ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Crack ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : ☐	